



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-13141W3
Job Sheet 185923



Part No: RBE105-13141W3

Job Qty: 1 ea

Part Name: Milling Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 12/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-13141W3 REV A IPP REV A 18.02.13 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/5/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs		12/5/18	0.00	1.00	Small Fab-3		MLC DAS
120	QC	1 pcs		12/5/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		12/5/18	0.00	0.00	Packaging3-1		9-88
140	QC21-SA	1 Ea		12/5/18	0.00	0.00	QC21		9-88

Part Op
Descriptions: 110 - 1-Assemble as per DWG. Sheet 1.

GA DEC 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
GZ1400940	Pilot	1 Ea (1 ea)	90-Start up Operation	5067337
H1402	Holder	1 Ea (1 ea)	90-Start up Operation	5067336
RBE105-13141W3-1	Base	1 Ea (1 ea)	90-Start up Operation	5069976
RBE105-13141W3-3	Plate	1 Ea (1 ea)	90-Start up Operation	5122079
RBE105-13141W3-5	Cutter	1 Ea (1 ea)	90-Start up Operation	5070949

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	GZ1400940	1	4	0
	H1402	1	4	0
	RBE105-13141W3-1	1	19	0
	RBE105-13141W3-3	1	19	0
	RBE105-13141W3-5	1	5	0



Container No: S136103



Part: RBE105-13141W3

Job No: 185923

Serial No/Batch: S136103

Revision: A
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ns

be found.

Plex 11/6/18 2:34 PM Dart.lajeunesse.marie

Date: 12/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

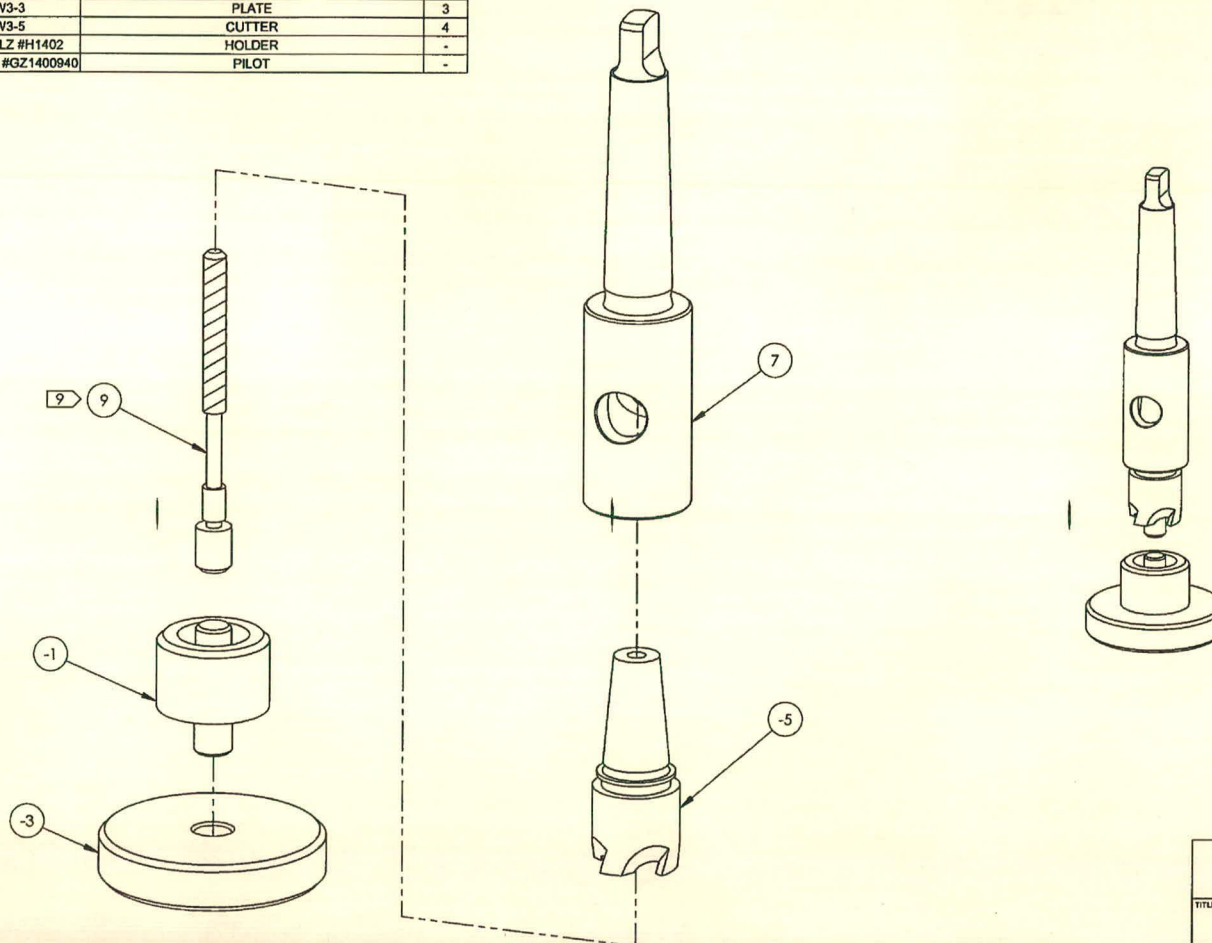
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐							

ITEM #	QTY	PART #	TITLE	PG
-1	1	RBE105-13141W3-1	BASE	2
-3	1	RBE105-13141W3-3	PLATE	3
-5	1	RBE105-13141W3-5	CUTTER	4
7	1	STEINER TECH. H. BILZ #H1402	HOLDER	-
9	1	STEINER TECH. H. BILZ #GZ1400940	PILOT	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
A	RELEASED FOR PRODUCTION	17-775	17.12.04	VM	ML



RBE105-13141W3 MILLING TOOL

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A/N/A
- 4) SPEC: N/A/N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) REF AIRBUS T/N: 105-13141W3
- 8) USED ON MODEL: EC135, EC145, EC835, EC845, H135
- 9) TIGHTEN NUTS UNTIL THE PILOT IS FLUSH BUT STILL ROTATES FREELY

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE MILLING TOOL	
PART NO.	RBE105-13141W3
TOOL NO.	RBE105-13141W3
DESIGNED BY:	VM 12/4/2017
DRAWN BY:	VM 12/04/2017
CHECKED BY:	VM 01/23/2018
MFG REVIEW BY:	DP 02/12/2018
APPROVED BY:	ML 03/08/2018
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
TOLERANCES: XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS
SCALE: NTS	SHEET 1 OF 4
COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

